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RBEM12669/P-1
Job Sheet 171011



Part No: RBEM12669/P-1

Job Qty: 1 ea

Part Name: Hoisting Tool Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBEM12669/P-1 REV:4 IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	1 pcs		1/30/18	0.08	0.08	Small Fab-9		MCC
101	QC	1 pcs		1/30/18	0.00	0.00	QC5		14 18-3-15
102	Mill Conv	1 pcs		1/30/18	0.00	0.20	Mill Conv 2		A.A 18-03-16
103	QC	1 pcs		1/30/18	0.00	0.00	QC2 Machining-3		A.A 18-03-16
104	QC	1 pcs		1/30/18	0.00	0.00	QC8		A.A 18-03-16
105	Small Fab	1 pcs		1/31/18	0.00	0.08	Small Fab-6		A.A 18-03-16
110	QC	1 pcs		1/31/18	0.00	0.00	QC5		14 17-7-20
130	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-2		Smg
140	QC21-FG	1 Ea		1/31/18	0.00	0.00	QC21	DAS	18/03/20

Part Op 100 - Assemble for drill and tap.

Descriptions: 102 - Tap drill Assembly .75 max depth -Start thread -Disassemble and finish tapping hole in -01

105 - Assemble using 262/ 263 locite -Install setscrew.

110 - Perform inspection and testing procedure. see sheet 4 of 4 of the attached dwg.

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	3 Ea (3 ea)	90-Start up Operation	
44124	Load Ring	1 Ea (1 ea)	90-Start up Operation	
92695A405	Set Screw	1 Ea (1 ea)	90-Start up Operation	
98296A911	Roll Pin	1 Ea (1 ea)	90-Start up Operation	
98335A790	Double Loop Hair Pin	1 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	.4170 ft (.417 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	1.3330 ft (1.333 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	
RBEM12669/P-1-01	Hoisting Tool Assembly	1 Ea (1 ea)	90-Start up Operation	
RBEM12669/P-1-03	Hoisting Tool Handle	1 Ea (1 ea)	90-Start up Operation	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Th
Part No. _____		
NCR No. _____		

Date : _____ Step #: _____

Description Work Order Deviation

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Root Cause

Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/ ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐



Engineering ☐
Quality ☐
Other ☐

QSI042) Approval

Completed By

Supervisor
Verification



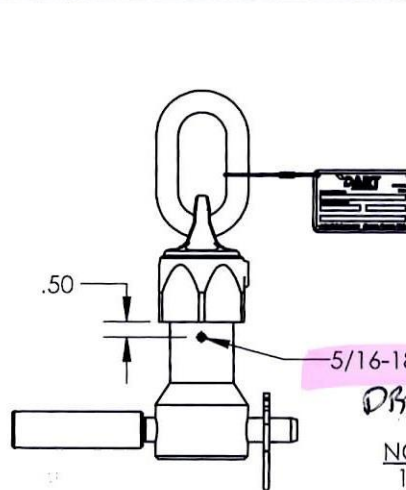
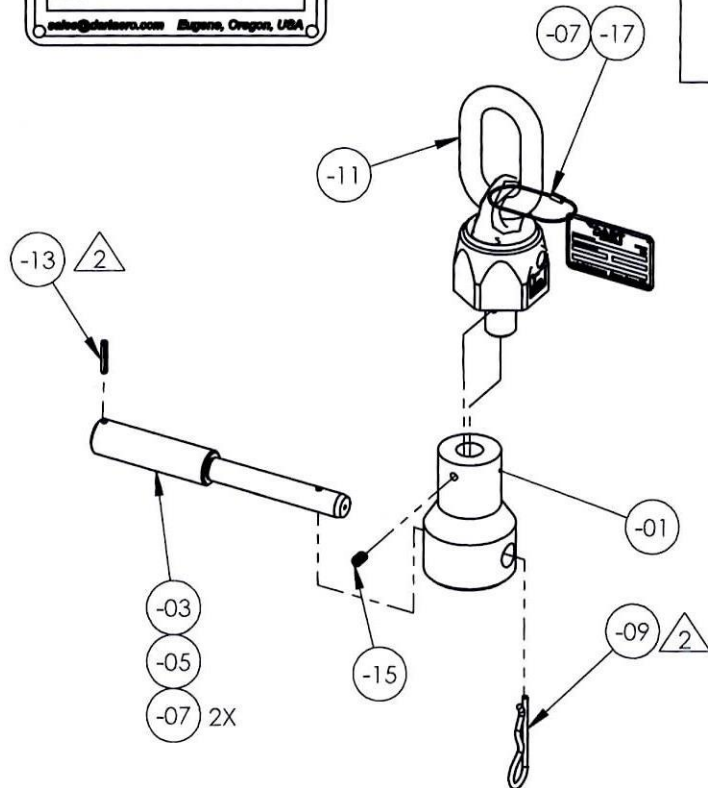
Off-set ☐
Mis-labeled ☐
Fit/Function ☐
Misaligned/off center ☐

Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-01 BODY O.D. CHANGE FROM 3.5 TO 3.00. -03 PIN LENGTHS CHANGED FROM 5.89 TO 5.00 AND 9.704 TO 9.25.	4/26/2017		
2		-01 ADDED 5/16-18 THREADED HOLE.	4/26/2017		
3		-01 DELETED 5/16-18 HOLE, WILL BE DRILLED AT ASSEMBLY.	4/26/2017		
4	17-0102	UPDATED TO NEW DRAFTING STANDADR. ADDED NOTE 2 TO SHEET 1. -01 DELETED DIM'S (.82), 1.65. ADDED DIM (1.75). CH'D FINISH WAS POWDER COAT FORREST T3370 S9 RED WAGON IS POWDER COAT RED. CH'D MAT'L WAS 1018 IS 1018/1020 CR. -03 CH'D DIM'S WAS .082 IS .08 WAS .0.736 IS .0.74. WAS .0.188 THRU IS .0.19 THRU ALL. WAS .0.550 IS .0.55 .75. WAS 2.25 .75. .025 IS .03. WAS .196 IS .20. ADDED DIM .63 (1.15). CH'D ENGRAVE NOTE WAS ENGRAVE TOOL No. TO FIT IS ENGRAVE P/N. WAS ENGRAVE TOOL No. "RBEM12669P-1 IS ENGRAVE T/N. S/N. "MADE IN USA". CH'D FINISH WAS CAD PLATE SILVER MIL-C-8156B. TYPE I. CLASS I IS ZINC PLATE ASTM B633 TYPE I SC 2. CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142 ADDED HEAT TREAT RC 28-34. -07 CH'D QTY WAS 2 IS 3. -09 CH'D B/O INFO WAS Ø3/16 LINKAGE PARTS #1099172 IS Ø9/64 X 3/4 (MCMMASTER-CARR #98355A790). -11 CH'D B/O INFO WAS 8800LB CAP. (RUD #7989905) GRAINGER #1MLT4 IS 10,000LB. CAP. WESTEC RIGGING, ACTEK #44124. ADDED -17 AND RB41011 SHEET 1 ADDED VIEW TOSHOW 5/16 HOLE POSITION. ADDED WEIGHT TEST SHEET.	4/26/2017	RJC	JAG



5/16-18 UNC -1B .63
 DRILL CHAMFER HOLE MAX Ø.7
 Mfg 03/16/18

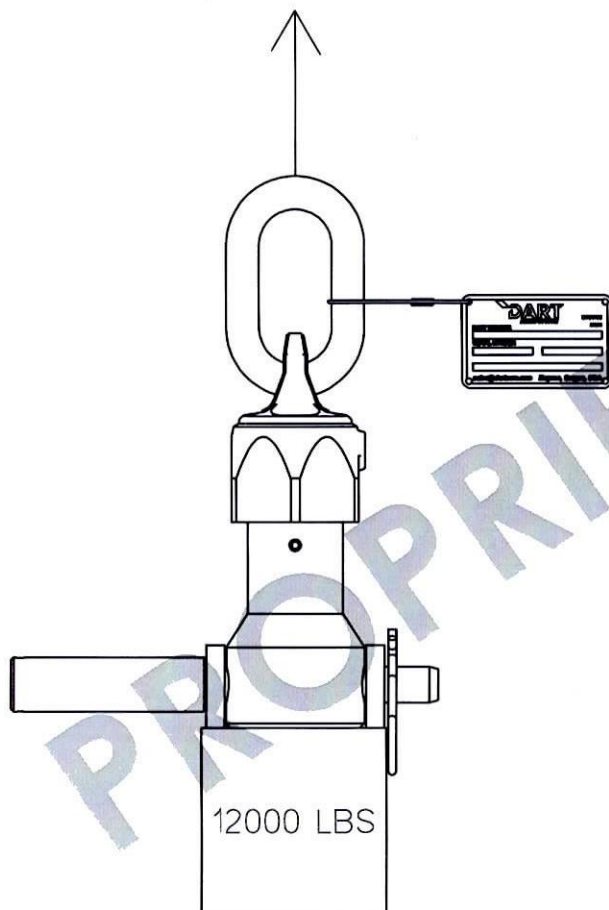
- NOTE:
- PART OF KIT RBEA62410.
 - ATTACH LANYARD TO -09 & -13.
 - ENGRAVE WITH T/N, S/N, SWL 3T WEIGHT TESTED AT 12000 LBS, DATED XX-XX-XXXX.
 - REF AIRBUS #M12669/P-1.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	BODY	1018/1020 CR		2
			-03	1	PIN	4140/4142		3
		B/O	-05	1	LANYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL-2-C)	N/S
		B/O	-07	3	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896T31)	N/S
		B/O	-09	1	DOUBLE LOOP HAIR PIN	STEEL	Ø9/64 X 3/4 (MCMMASTER-CARR #98335A790)	1
		B/O	-11	1	LOAD RING		10,000 LB. CAP. WESTEC RIGGING, ACTEK #44124	1
		B/O	-13	1	ROLL PIN	STEEL	Ø3/16 X 1-1/8 (MCMMASTER-CARR #98296A911)	1
		B/O	-15	1	SET SCREW	STEEL	5/16-18 X 5/8 (MCMMASTER-CARR #92695A405)	1
		B/O	-17	1	LANYARD	COATED STEEL	Ø1/16 X 3 (CARR LANE #CL-2-C)	1
		B/O		1	PLACARD	ALUMINUM	RB41011	1

DART AEROSPACE	
TITLE HOISTING TOOL ASSEMBLY	
DWG NO. RBEM12669/P-1	REV 4
MAT'L REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: DD 04/26/2017 OPPTS APPR: AA 05/05/2017 QA APPR: JL 05/10/2017 APPROVED: JAG 05/16/2017 SCALE 1:6 DATE 4/26/2017 SHEET 1 OF 4	

APPLY WEIGHT 262/263 TO ALL TABCARD RBEM TO ASSY

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INSPECTION & TESTING PROCEDURES FOR THE RBEM12669/P-1, HOISTING TOOL ASSEMBLY. THIS IS DESIGNED FOR LIFTING THE EC135, H135, AND EC635 HELICOPTER. THIS HOISTING TOOL SHOULD BE INSPECTED BEFORE AND AFTER EACH USE.

REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE HOISTING TOOL ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT TEST OF 12,000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGE.
3. REMOVE WEIGHT AND RE-INSPECT, CHECKING FOR ANY CRACKS, DEFLECTION, DISTORTION OR DAMAGE.

INSPECTOR: Jason Lewis

TESTER: ALAIN PATRY

S.N.: S052509

DATE: 3-19-2018

DART
AEROSPACE

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TITLE

HOISTING TOOL ASSEMBLY

DWG NO.

RBEM12669/P-1

REV

4

CUSTOMER 1 OF 1

SCALE

1:4

DATE

4/26/2017

SHEET

4 OF 4